

who was sent for 14
8/9/2008

30

Work Order ID 51652-2

August 27, 2009 8:39:41 AM

SPLIT-2

Item ID: D3405-043
Revision ID: B
Item Name: Lug Assembly
Start Date: 8/27/09
Required Date: 9/11/09
Reference:

(14)
2009/09/23

Start Qty: 32.00
Req'd Qty: 32.00



Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals:

Process Plan:

QC: *RC*

Date: 08-27-09

Tooling:

Date:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw Number Draw Rev. Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D3405

Rev B

100



Waterjet
FLOW CNC Waterjet

FLOW WATER JET

0.00

Memo

1-Cut as per Dwg D3405
Deburr if necessary

Dwg Rev: B Prog Rev: B 2-

0.00

IB 9-9-17

(L14)

110



QC
Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

IB 9-9-17

120



QC
Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

=> S on 10/17

(circled signature)

4

Work Order ID 51652

August 27, 2009 8:39:41 AM



Page 2

Item ID: D3405-043
Revision ID: B
Item Name: Lug Assembly

Start Date: 8/27/09 Start Qty: 32.00
Required Date: 9/11/09 Req'd Qty: 32.00



Cust Item ID:
Customer:

Accept



Setup Start



Stop



Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Deburr Form using DT8204 as per Dwg D3405

0.00

0.00

SB 09/09/21

44

0

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

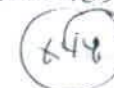
Memo

0.00

0.00

2 Sclorize

(unf)



4

150



Large Fab

Large Fab

Large Fab

Memo

Weld as per Dwg D3405 Identify as D3405-043

0.00

0.00

~~M102000~~
M102000

~~SB 09/09/21~~

EL 9-10-8 (X) H

Work Order ID 51652

August 27, 2009 8:39:41 AM

Item ID: D3405-043
Revision ID: B
Item Name: Lug Assembly

Start Date: 8/27/09 Start Qty: 32.00
Required Date: 9/11/09 Req'd Qty: 32.00

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC9- Inspect visual per QSI004- Fusion Welds

Memo

Set Up/
Run Hours

0.00

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

091013

07 07 23

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

2 Sorboly

14

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

START TIME:

1:30pm FINISH TIME:

0.00

0.00

OVEN TEMPERATURE:

400°F

09/10/14 14



Work Order ID 51652
August 27, 2009 8:39:41 AM



Accept



Setup Start



Stop



Item ID:
Revision ID:
Item Name:
Start Date:
Required Date:
Reference:

D3405-043

B

Lug Assembly

8/27/09

Start Qty: 32.00

9/11/09

Req'd Qty: 32.00



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

QC3- Inspect Part Finish

0.00

Memo

0.00

Identify as per dwg & Stock Location: 474

0.00

Memo

0.00

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Per 9/10/15 (14)

Per 9/10/15 (14)

09/10/15

ME 09-10-15

190
QC
Quality Control

200
Packaging
Packaging

210
QC
Quality Control

Picklist Print

August 27, 2009 8:39:40 AM

Work Order ID: 51652

Parent Item: D3405-043RevB

Parent Item Name: Lug Assembly

Comments:

Component Item ID/
Item Name

Replacement
Item ID

Mfg/
Purch

Bin
Item

Primary
Location

Last
Location

Route
Seq ID

Unit of
Measure

Qty on
Hand

Remaining
Qty To Pick

Qty
Issued

Date
Issued

Status

Manufactured

No

100

Each

33.0000

32.0000

44



D3404-1 RevC



GHW Lug

Warehouse

Loc Qty

Loc Code

Location

51548

Main Warehouse

ST

33

45372

8

50471

25

150

sf

63.6179

5.1874



Purchased

No

52314

x 14

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

63.61789789

111018

63.6178979

111018

M304S11GA



304/316 0.125 Sheet

Start Date: 8/27/09

Start Qty: 32.00

Required Date: 9/11/09

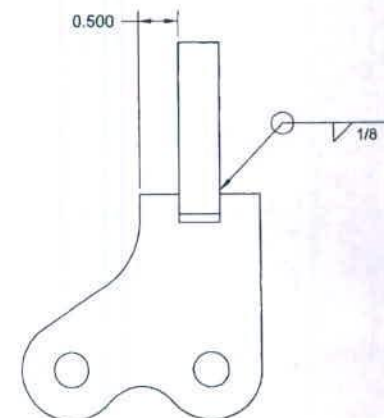
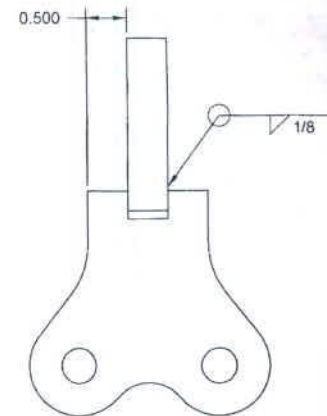
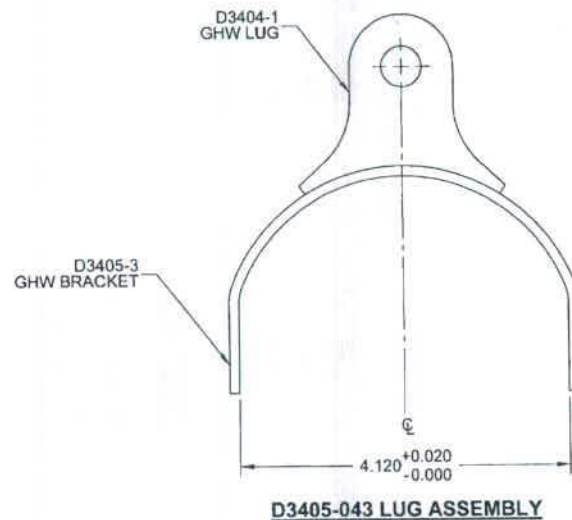
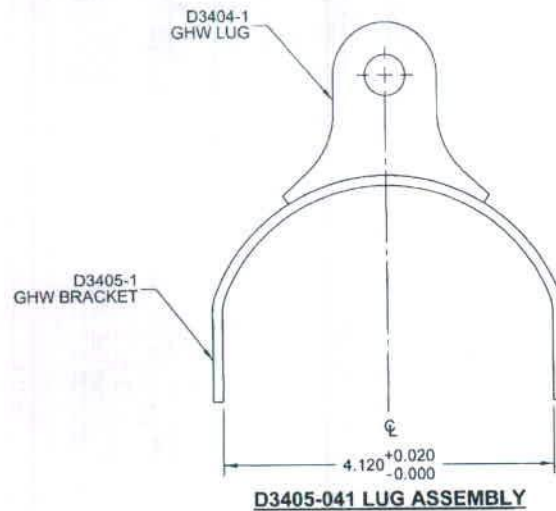
Required Qty: 32.00

✓ 30

SP 09.09.23

EL 9-10-8 (x14)
B 9-9-17

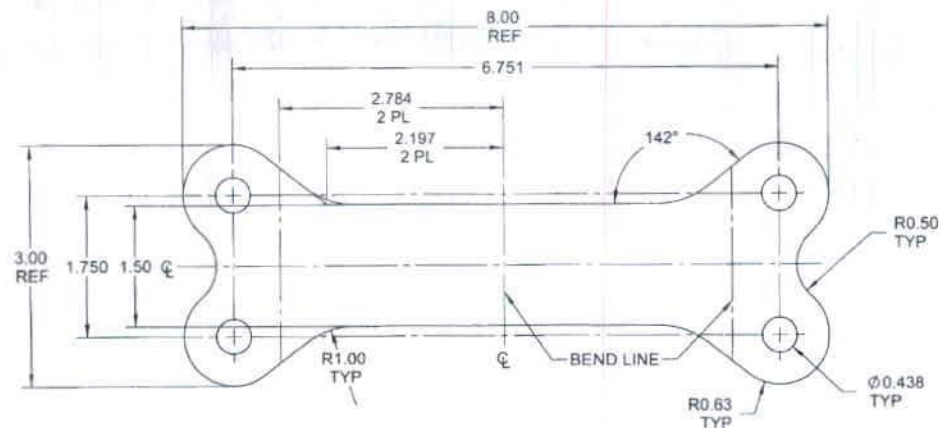




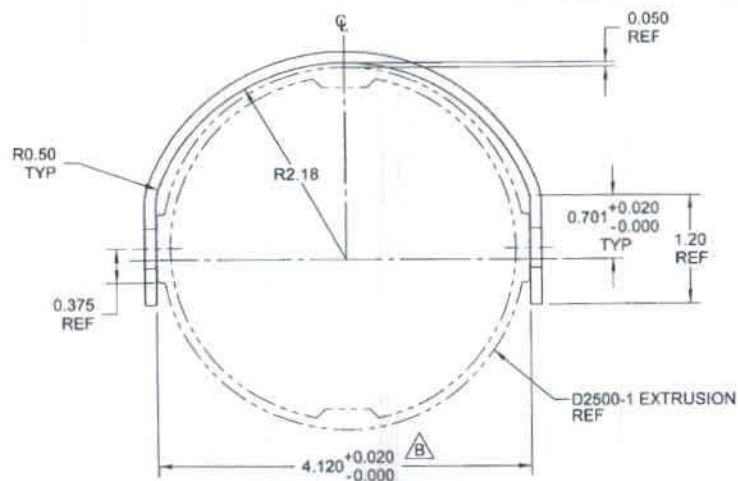
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08/12/18

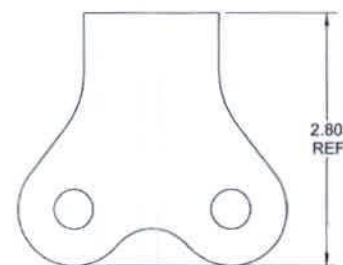
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DRAWN	AJS		
CHECKED		DRAWING NO. D3405	REV. B
MFG. APPR.		TITLE	SHEET 2 OF 4
APPROVED		GHW LUG ASSEMBLY	SCALE
DE APPR.			NTS
DATE	08.09.19	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)

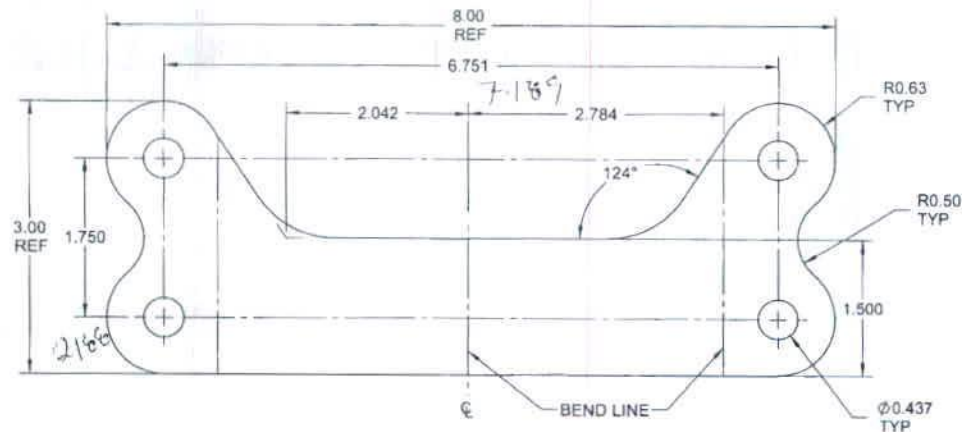


SIDE VIEW FOR REF ONLY

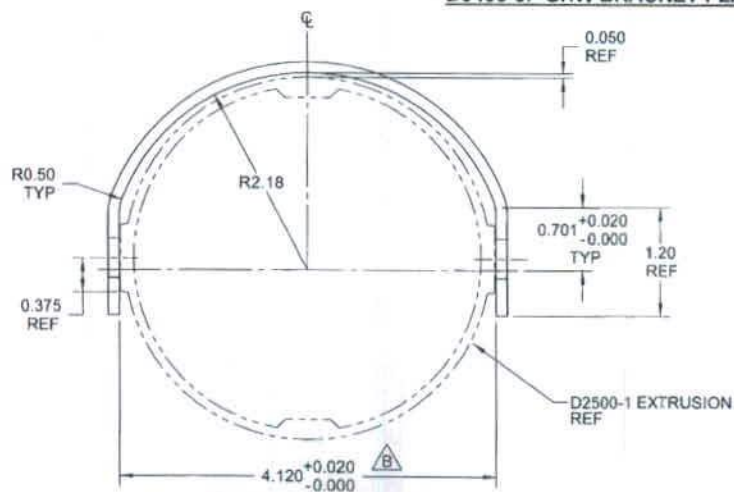
- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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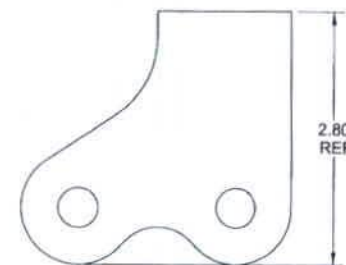
51652
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01/28/21



D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3405	SHEET 4 OF 4
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